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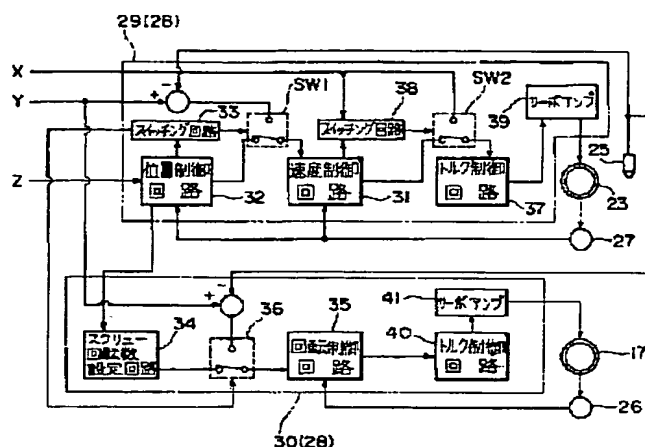
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TITLE : MATERIAL SUPPLY CONTROLLING
DEVICE OF ELECTRICALLY-DRIVEN
INJECTION MOLDING MACHINE



ABSTRACT : PURPOSE: To avoid unevenness in measurement of material by causing an injection screw to stop precisely at a predetermined measurement completion position.

CONSTITUTION: When materials are supplied, pressures of the materials detected by a pressure sensor 25 are inputted into a retraction control means 29 and a rotation control means 30 and back pressure command values Y are, inputted into a speed control circuit 31. In the means 29, a forward and backward motor 23 is controlled by means of a servo-amplifier 39 based on retracting speed, number of revolution, and torque corresponding to the deviation between the values Y and actual pressures. In the means 30, number of revolution corresponding to screw positions obtained by an encoder 27 is set at a screw revolution set circuit 34 and outputted from a rotation control circuit 35, whereby rotation of screw is controlled by a servo-amplifier 41, so that back pressure is controlled. On the other hand, when the screw has been retracted to a predetermined position, a switching circuit 33 is actuated to input position and speed reduction command values from a position control circuit 32 into the circuit 31, whereby the screw is stopped precisely at a predetermined position.

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